

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025973**Date Inspected:** 03-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China**CWI Name:** N / A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

BLASTING INSPECTION**Segment 13AW**

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13CW at counter weight side, after the grit blast of the external components of bottom plate, Side plate & floor beam of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ABF QC personnel are aware of these areas and were present during the inspection. The defects were

AT East side of PP119.65:

1. Seg3013D: Section AY2 [C4 (of weld map)] - RS web to Flange - grinding notch observed.
2. FB3194A: Base metal depression (of dia approx 75mm x 5mm deep) observed on X4157A stiffener plate of

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FB3194A.

3. FB3194A: Base metal damage (dia 20mm x 5mm deep - approx) observed on X4157A stiffener plate of FB3194A.

4. Seg3013D: Base metal damage (of dia approx 25mm x 6mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

5. Seg 3013D: Base metal damage (between 3rd and 4th RS3439D stiffeners - from KP3016A and at east side of FB3194A, near FB to SP weld) observed on SP3101A.

AT West side of PP120:

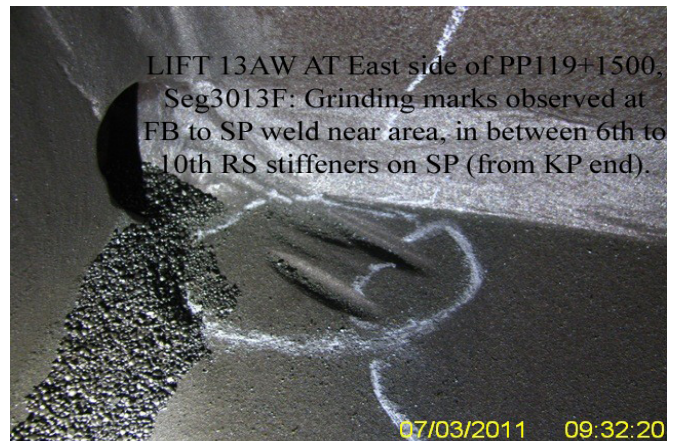
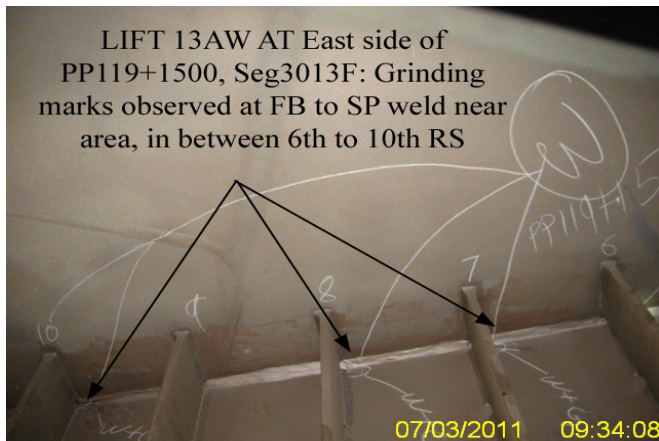
1. Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

2. Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

AT East side of PP119+1500):

1. Seg3013F: Grinding marks observed at FB to SP weld near area(at I-rib on SP to FB) at 6th to 10th RS stiffeners on SP (from KP end). See the attached picture.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer